

Date: Tuesday, 16/01/2007 9:57:01 AM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STIFFNER		
Job Number	: 30288		Part Number	: G106046		
Estimate Number	: 12642		Drawing Number	: G10604 REV A		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 16/01/2007 S.O. No. : N/A		Drawing Revision	: A		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 26/01/2007 Qty: 10 Um: Each		
Previous Run	: N/A					
Written By	: <u>U</u>					
Checked & Approved By	: <u>U</u>					
Comment	: Est Rev:A New Issue 07-01-16 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S050	2024-T3 .050 sheet Comment: Qty.: 0.2615 sf(s)/Unit Total : 2.6145 sf(s) 2024-T3 .050 sheet *****Grain must Run Along 8.59" Dim ***** Batch: M103210 - ml 07 01 16 (10)
2.0	WATER JET	FLOW WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg G10604 Dwg Rev: A Prog Rev: A 2-Deburr if necessary *****Use same cutting file for -3 & -6 ***** ml 07 01 16 (10)
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE Comment: INSPECT PARTS AS THEY COME OFF MACHINE ml 07 01 16 (10)
4.0	QC8	SECOND CHECK Comment: SECOND CHECK ml 07 01 16 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/01/2023
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-C'SINK AS PER DWG G10604,
****NOTE:-3 & -6 ARE C'SINKED ON OPPOSITE SIDES****

FP 07-01-19 10

2-FORM AS PER DWG G10604

SB 07/01/19 00

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DA 07/01/19 00

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

LS 1 07/01/22 10

07/01/22 10

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/01/22 10

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/01/22 10

07/01/22 10

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/01/22 10

Job Completion



07/01/22

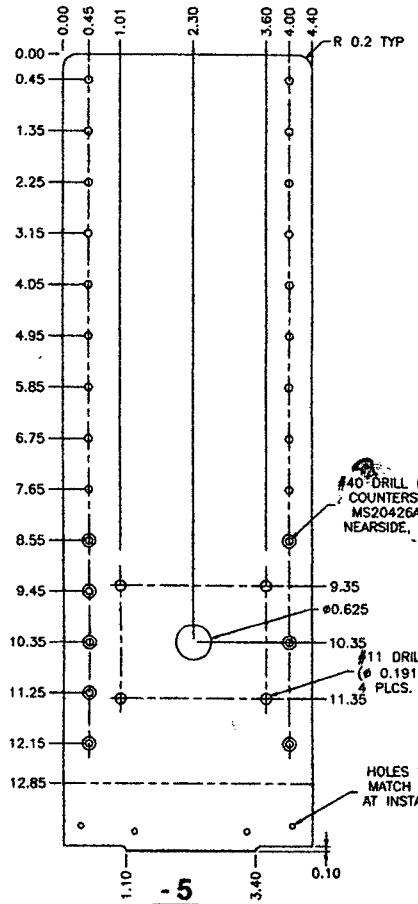
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

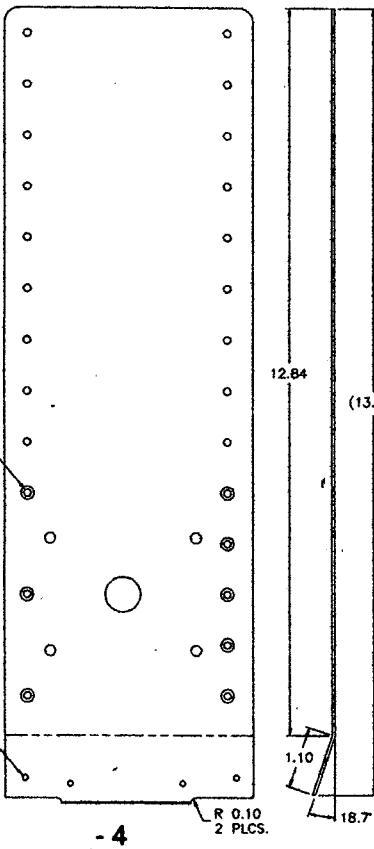
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NCR Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REVISION		DATE	APPROV.
REV	DESCRIPTION		
A	- COMBINE SHEET 1 AND 2. - CHANGE DRAWING FORMAT. - UPDATE DIMENSIONS AND NOTES. - ECO 1038, 1040	4/8/01	



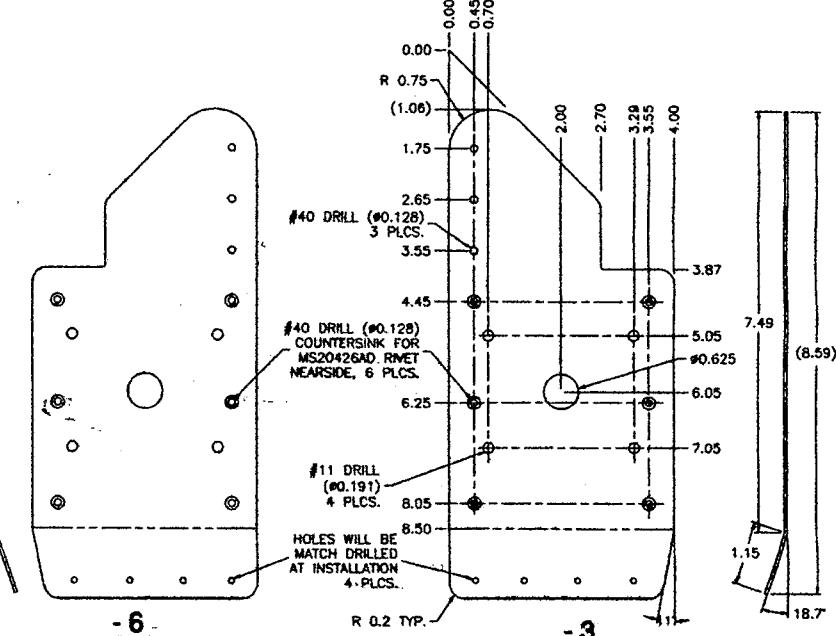
-4 AND -5 FLAT PATTERN ARE IDENTICAL
EXCEPT BENDS ARE OPPOSITE SIDE
AND COUNTERSINK AS NOTED



NOTES:

UNLESS OTHERWISE NOTED.

1. MAT'L: ALUM 0.050 THICK. 2024-T3
QQA-250/4
2. ALL PILOT HOLES ARE #40 DRILL (#0.098),
TO BE DRILLED TO SIZE AT ASSEMBLY.
3. FINISH: ETCH, ALODINE PER MIL C5541-1A,



-3 AND -6 FLAT PATTERN ARE IDENTICAL
EXCEPT BENDS ARE OPPOSITE SIDE
AND COUNTERSINK AS NOTED

X10

DRAWN ALL EDGES		DRWNS	T. S.	DATE
UNLESS OTHERWISE SPECIFIED		CHECK	DATE	3/20/95
DIMENSIONS ARE IN INCHES		DESIGN	DATE	
DIMENSIONAL TOLERANCES		APPROVAL	DATE	
3 DECIMALS $\pm .010$		RGC	DATE	4/3/95
2 DECIMALS $\pm .020$				
1 DECIMAL $\pm .080$				
ANGULAR $\pm 1^\circ$				
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DRAW NO.		G10604	REV.	A
PROJ NO.		GA159	ISSUE	1/1
			MT	1 OF 1

GENEVA AVIATION
10108 - 32nd Ave W
Everett, WA 98204
(425)353-7400 FAX(425)347-7100
REAR SHOULDER HARNESS
STIFFENER

DART AEROSPACE LTD	Work Order:	30288
Description: stiffener	Part Number:	G10604L
Inspection Dwg: D G10604, Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article **X** Prototype

Measured by:	ml: mH
Date:	07/01/16

Audited by:	<u>AA</u>
Date:	07/01/16

Prototype Approval:	<i>N/A</i>
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

21
2018

SHIP TO:						
Kaiser Aluminum 7000 E. 25th Street Trentwood Works - Spokane, WA 99215 Phone: (800) 367-2586						
SOLD TO:						
Kaiser Aluminum 7000 E. 25th Street Trentwood Works - Spokane, WA 99215 Phone: (800) 367-2586						
CUSTOMER PO NUMBER: N18187		WORK PACKAGE:	CUSTOMER PART NUMBER:		SHIP RACKLOAD ID: 100080/10	GOVT CONTRACT NUMBER:
KAISER ORDER NO: 1033832	LINE ITEM: 1	SHIP DATE: 24-MAR-2008	ALLOY: 2024	CLAD: CLAD	TEMPER: T1	
WEIGHT SHIPPED: 7885 LB	QUANTITY: 223 PCS EST.	INV. NUMBER: 207885	GAUGE: 0.0500 IN	WIDTH: 48.000 IN	LENGTH: 1-4,000 IN	

KAISER
ALUMINUM

Trentwood Works - Spokane, WA 99215
Phone: (800) 367-2586

CERTIFIED TEST REPORT

Serial Number
4062914

Certified Specifications

AMS 4041/RevP
BATS 2505/RevNC

AMS QQ-A-2805/RevA
DMS 2174/RevB

ASTM B 209/Rev04

Test Code: 4013

Test Results

Lot: 350042AB Cast 318

Drop 16

Ingot 2

Tensile:	Temper	Dir / # Tests	Ultimate KSI (MPA)	Yield KSI (MPA)	Elongation %
	T3	LT / 2 (Min:Max)	63.8 : 64.7 ✓ (441 : 446)	44.8 : 45.8 ✓ (309 : 316)	15.3 : 15.6 ✓

MRS Deflection: 0.017 IN

Chemistry:	Si /	FE /	CU /	MN /	MG /	CR /	ZN /	T1 /	V /	ZR /	OTHER /
Actual	0.09	0.24	4.57	0.59	1.40 ✓	0.01 ✓	0.19	0.02	0.01	0.01	0.04

ALLOY LIMITS

Chemistry:	Si	FE	CU	MN	MG	CR	ZN	T1	V	ZR	OTHER	MAX
2024 MIN	0.00	0.00	3.80	0.30	1.20	0.00	0.00	0.00	0.00	0.00	EACH	0.05
MAX	0.50	0.50	4.90	0.80	1.80	0.10	0.26	0.15	0.05	0.05	TOT	0.15
LINER MIN	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	EACH	0.03
MAX	0.25	0.40	0.05	0.05	0.05	0.00	0.08	0.03	0.05	0.00	TOT	0.00

Aluminum Remainder

TEST NOTES

MATERIAL MEETS MINIMUM RESIDUAL STRESS (MRS)Y CHEMICAL MILLING QUALITY (CMQ) REQUIREMENTS.



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